

## WHAT IS CLAIMED:

1. A process cartridge detachably attached to an image forming apparatus, comprising:
  - an image carrier configured to carry an image;
  - at least one image forming process device configured to perform image forming processes;
  - a case configured to integrally accommodate the image carrier and the at least one image forming process device; and
  - a first non-slip holding portion provided on a surface of the case,wherein the process cartridge is configured to move in a direction substantially parallel to a longitudinal direction of the image carrier, and insertion or removal of the process cartridge from the image forming apparatus is facilitated by grasping the process cartridge by the first non-slip holding portion and a rear surface of the case opposite from the first non-slip holding portion.
2. The process cartridge according to claim 1, further comprising:
  - a second non-slip holding portion provided on the rear surface of the case, wherein insertion or removal of the process cartridge from the image forming apparatus is facilitated by grasping the process cartridge by the first and the second non-slip holding portions.
3. The process cartridge according to claim 1, wherein the case further comprises an opening exposing at least a portion of the image carrier, and the surface of the case containing the first non-slip holding portion is oriented along a direction substantially equal to a direction of a surface of the image carrier exposed through the opening.
4. The process cartridge according to claim 3, wherein the surface on which the first non-slip holding portion is provided is in a stepped relationship relative to the surface of the image carrier exposed through the opening.
5. The process cartridge according to claim 4, wherein the surface on which the first non-slip holding portion is provided is located at a position lower than the surface of the image carrier exposed through the opening.

6. The process cartridge according to claim 1, wherein the surface of the case containing the first non-slip holding portion is disposed on a front side of the case substantially oriented in a direction of movement of the process cartridge from an inserted position to a pulled-out position.

7. The process cartridge according to claim 6, wherein the first non-slip holding portion is disposed at a position opposite from a position of the image carrier relative to a center position of the case in a substantially horizontal direction of the case orthogonal to the direction of movement of the process cartridge.

8. The process cartridge according to claim 6, further comprising:  
a grip configured to be gripped when the process cartridge is moved between the inserted position and the pulled-out position, the grip being provided on a frontal wall surface of the case in the direction of movement of the process cartridge.

9. The process cartridge according to claim 8, wherein the image carrier is configured to rotate, and the first non-slip holding portion and the grip are provided on sides opposite to each other relative to a vertical plane containing a rotational axis of the image carrier.

10. The process cartridge according to claim 9, wherein a distance between the first non-slip holding portion and the rotational axis of the image carrier is greater than a distance between the grip and the rotational axis of the image carrier.

11. The process cartridge according to claim 1, wherein the first non-slip holding portion is distinguished from a surface of the case other than the surface of the case on which the first non-slip holding portion is provided.

12. The process cartridge according to claim 11, wherein a frictional coefficient of the first non-slip holding portion is greater than a frictional coefficient of the surface of the case.

13. The process cartridge according to claim 12, wherein the first non-slip holding portion is formed by carving the surface of the case.

14. The process cartridge according to claim 12, wherein the first non-slip holding portion is formed by attaching a member to the surface of the case.

15. The process cartridge according to claim 1, wherein the at least one image forming process device comprises at least one of a developing device configured to develop the image carried by the image carrier, a charging device configured to charge a surface of the image carrier, and a cleaning device configured to clean the surface of the image carrier.

16. An image forming apparatus, comprising:  
an image carrier configured to carry an image;  
image forming process devices configured to perform image forming processes;  
a process cartridge detachably attached to the image forming apparatus, the process cartridge comprising:  
a case configured to integrally accommodate the image carrier and at least one of the image forming process devices; and  
a first non-slip holding portion provided on a surface of the case,  
wherein the process cartridge is configured to move in a direction substantially parallel to a longitudinal direction of the image carrier, and insertion or removal of the process cartridge from the image forming apparatus is facilitated by grasping the process cartridge by the first non-slip holding portion and a rear surface of the case opposite from the first non-slip holding portion.

17. The image forming apparatus according to claim 16, further comprising:  
a second non-slip holding portion provided on the rear surface of the case, wherein insertion or removal of the process cartridge from the image forming apparatus is facilitated by grasping the process cartridge by the first and the second non-slip holding portions.

18. The image forming apparatus according to claim 16, wherein the case further comprises an opening exposing at least a portion of the image carrier, and the surface of the case containing the first non-slip holding portion is oriented along a direction substantially equal to a direction of a surface of the image carrier exposed through the opening.

19. The image forming apparatus according to claim 18, wherein the surface on which the first non-slip holding portion is provided is in a stepped relationship relative to the surface of the image carrier exposed through the opening.

20. The image forming apparatus according to claim 19, wherein the surface on which the first non-slip holding portion is provided is located at a position lower than the surface of the image carrier exposed through the opening.

21. The image forming apparatus according to claim 16, wherein the surface of the case containing the first non-slip holding portion is disposed on a front side of the case substantially oriented in a direction of movement of the process cartridge from an inserted position to a pulled-out position.

22. The image forming apparatus according to claim 21, wherein the first non-slip holding portion is disposed at a position opposite from a position of the image carrier relative to a center position of the case in a substantially horizontal direction of the case orthogonal to the direction of movement of the process cartridge.

23. The image forming apparatus according to claim 21, further comprising:  
a grip configured to be gripped when the process cartridge is moved between the inserted position and the pulled-out position, the grip being provided on a frontal wall surface of the case in the direction of movement of the process cartridge.

24. The image forming apparatus according to claim 23, wherein the image carrier is configured to rotate, and the first non-slip holding portion and the grip are provided on the sides opposite to each other relative to a vertical plane containing a rotational axis of the image carrier.

25. The image forming apparatus according to claim 24, wherein a distance between the first non-slip holding portion and the rotational axis of the image carrier is greater than a distance between the grip and the rotational axis of the image carrier.

26. The image forming apparatus according to claim 16, wherein the first non-slip holding portion is distinguished from a surface of the case other than the surface of the case on which the first non-slip holding portion is provided.

27. The image forming apparatus according to claim 26, wherein a frictional coefficient of the first non-slip holding portion is greater than a frictional coefficient of the surface of the case.

28. The image forming apparatus according to claim 27, wherein the first non-slip holding portion is formed by carving the surface of the case.

29. The image forming apparatus according to claim 27, wherein the first non-slip holding portion is formed by attaching a member to the surface of the case.

30. The image forming apparatus according to claim 16, wherein the image forming process devices comprise at least one of a developing device configured to develop the image carried by the image carrier, a charging device configured to charge a surface of the image carrier, and a cleaning device configured to clean the surface of the image carrier.

31. The image forming apparatus according to claim 16, wherein the image forming apparatus forms single-color images.

32. The image forming apparatus according to claim 16, further comprising a plurality of process cartridges to form multi-color images.

33. A process cartridge detachably attached to an image forming apparatus, comprising:

image carrying means for carrying an image;

image forming process means for performing image forming processes;

accommodating means for accommodating at least one of the image carrying means and the image forming process means; and

a first non-slip holding means for facilitating handling the process cartridge, the first non-slip holding means being provided on a surface of the accommodating means,

wherein the process cartridge is configured to move in a direction substantially parallel to a longitudinal direction of the image carrying means, and insertion or removal of the process cartridge from the image forming apparatus is facilitated by grasping the process cartridge by the first non-slip holding means and a rear surface of the accommodating means opposite from the first non-slip holding means.

34. The process cartridge according to claim 33, wherein the image forming process means comprises at least one of developing means for developing the image carried by the image carrying means, charging means for charging a surface of the image carrying means, and cleaning means for cleaning the surface of the image carrying means.

35. An image forming apparatus, comprising:  
image carrying means for carrying an image;  
image forming process means for performing image forming processes;  
a process cartridge detachably attached to the image forming apparatus, the process cartridge comprising:  
    accommodating means for accommodating at least one of the image carrying means and the image forming process means; and  
    a first non-slip holding means for facilitating handling the process cartridge, the first non-slip holding means being provided on a surface of the accommodating means,  
    wherein the process cartridge is configured to move in a direction substantially parallel to a longitudinal direction of the image carrying means, and insertion or removal of the process cartridge from the image forming apparatus is facilitated by grasping the process cartridge by the first non-slip holding means and a rear surface of the accommodating means opposite from the first non-slip holding means.

36. The image forming apparatus according to claim 35, wherein the image forming process means comprises at least one of developing means for developing the image carried by the image carrying means, charging means for charging a surface of the image carrying means, and cleaning means for cleaning the surface of the image carrying means.